

Date: Tuesday, 10/06/2008 12:54:33 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD				
Job Number	: 39792							
Estimate Number	: 12784							
P.O. Number	:			Part Number	: D35649			
This Issue	: 10/06/2008	S.O. No. :		Drawing Number	: D3564 REV D			
Prsht Rev.	: NC			Project Number	: N/A			
First Issue	: / /	Type :		Drawing Revision	: D			
Previous Run	: 38656			Material	:			
Written By	:			Due Date	: 23/06/2008			
Checked & Approved By	: <u>JUL 08.6.10</u>			Qty:	20			
Comment	: Est Rev:A New Issue 07-03-08 ec			Um:	Each			
	Est Rev:B As per Rev C 07-07-09 JLM							
	Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 26.
		Comment: Qty.: 1.1550 sf(s)/Unit Total : 23.1000 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>108156</u> <u>HB 8-6-11</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: <u>B</u> <u>HB 8-6-11</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>HB 8-6-11</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>HB 8-6-11</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>S 08/06/11</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		 <u>SBS 08/06/11</u>
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 39792		Part Number: D35649
Job Number:		
Seq. #:	Machine Or Operation:	Description :
Form Joggle as per Dwg D3564 on brake using Jig DT 8157		
6.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1  Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R 2059B Hardcoat 4107962 Weld hardcoat as per Dwg D3564
8.0	QC10	VISUAL INSPECTION OF GROUND WELDS  Comment: VISUAL INSPECTION OF GROUND WELDS
9.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP
10.0	POWDER COATING	POWDER COATING  Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: 2:20 OVEN TEMPERATURE: 320°F FINISH TIME: 2:50
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
12.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 39792

Part Number: D35649

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/23 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

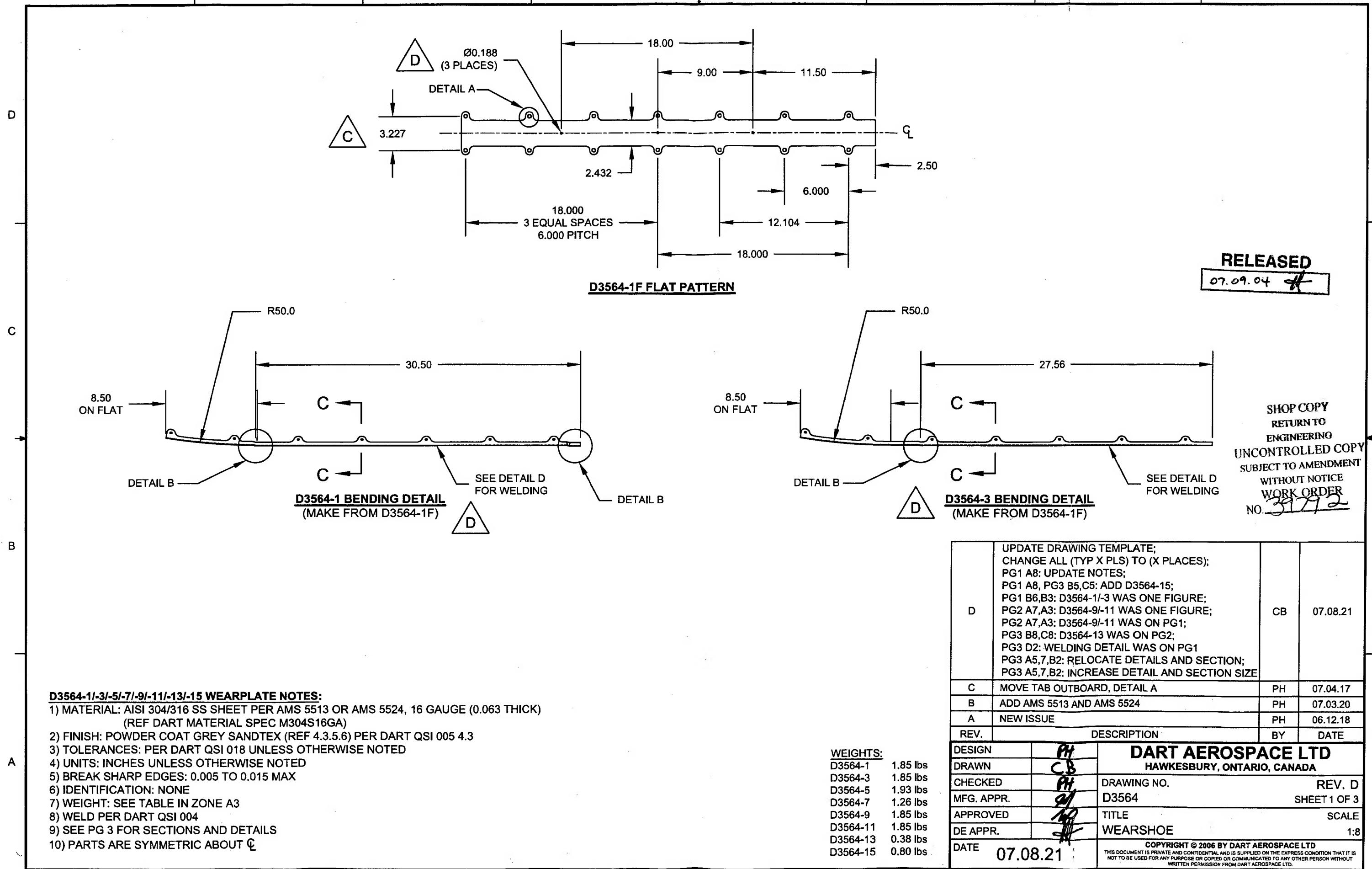
DART AEROSPACE LTD	Work Order:	39792
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

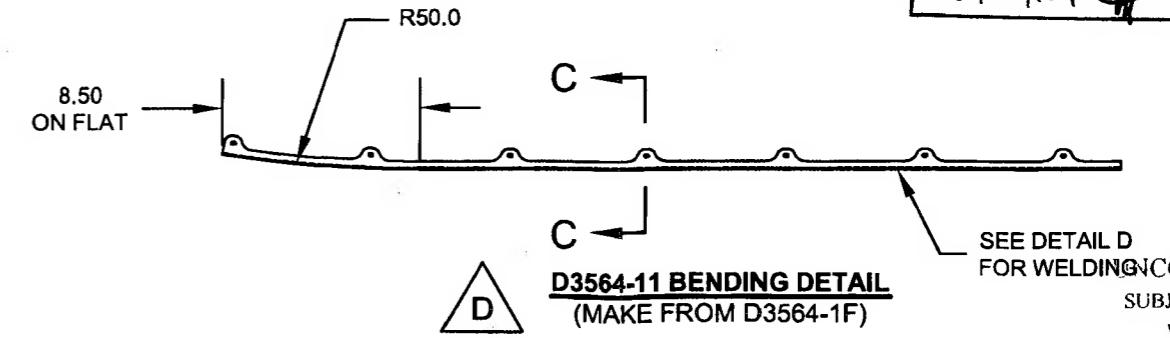
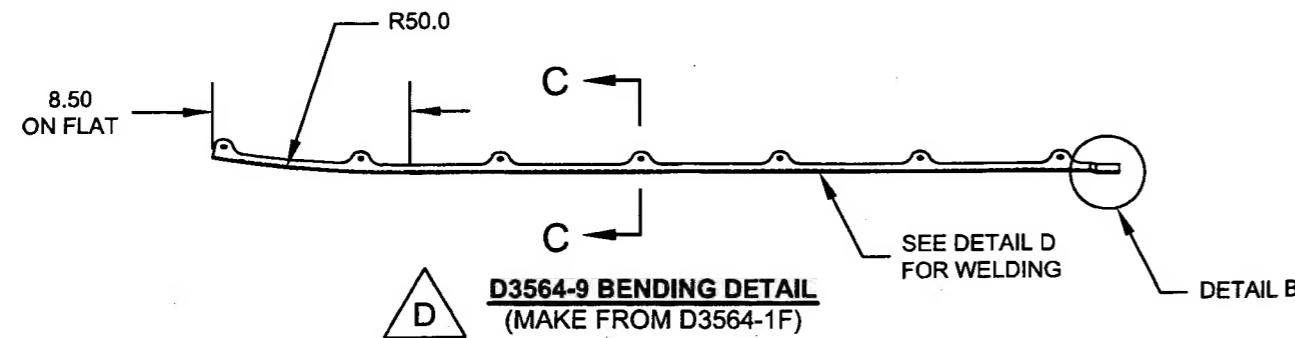
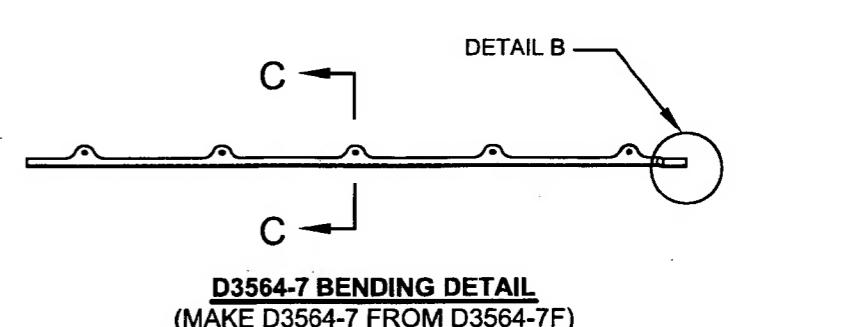
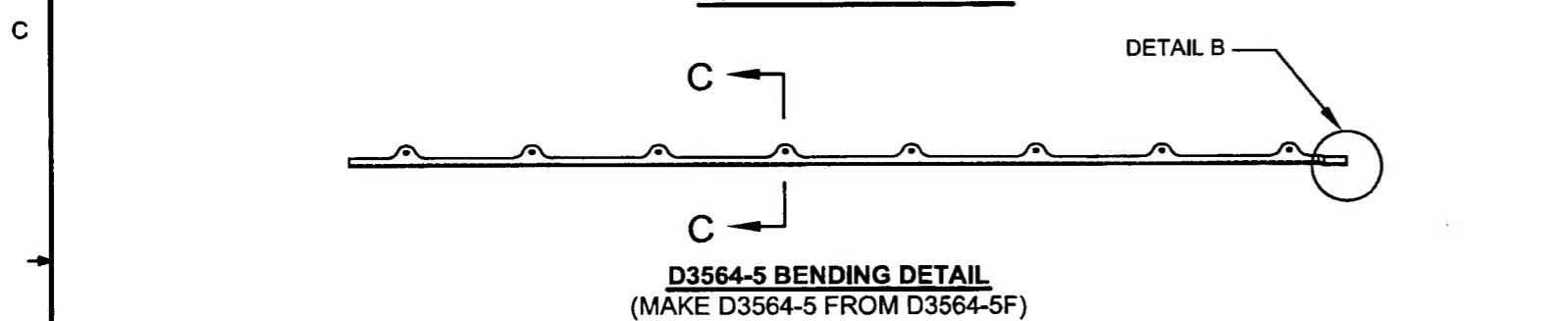
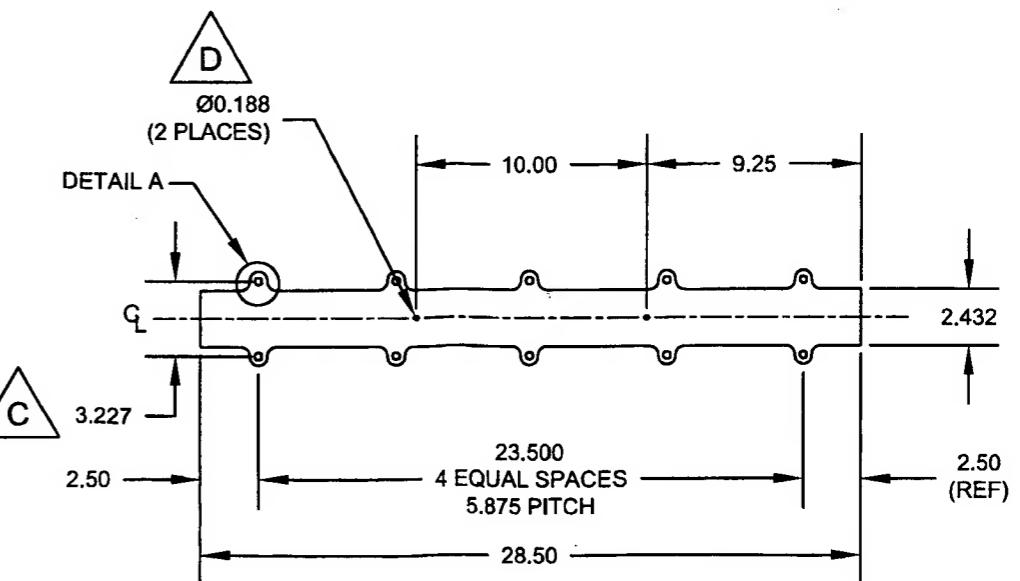
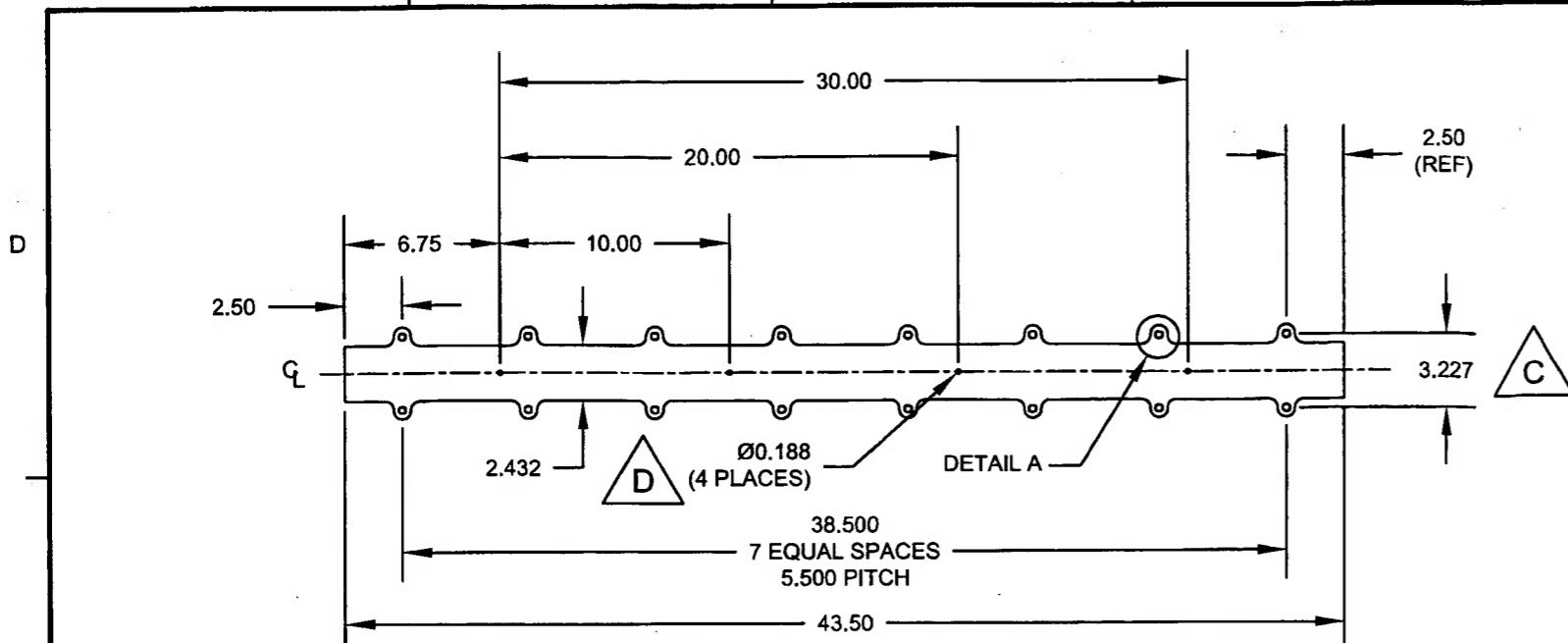
Measured by:	BB	Audited by:	S. G. H.	Prototype Approval:	N/A
Date:	8-6-11	Date:	08/07/11	Date:	N/A
Rev	Date	Change	08/07/11	Revised by	Approved
A	08.01.16	New Issue		KJ/EC/DD	

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



RELEASED

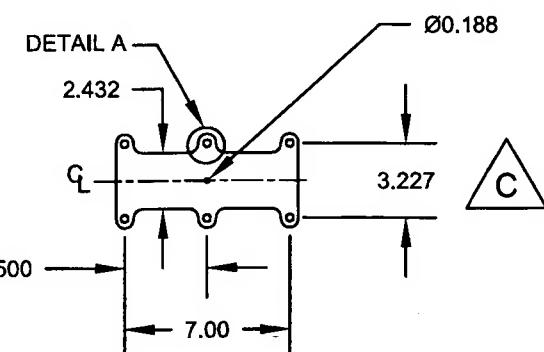
07.09.04 #

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WORK ORDER
NO. 37710

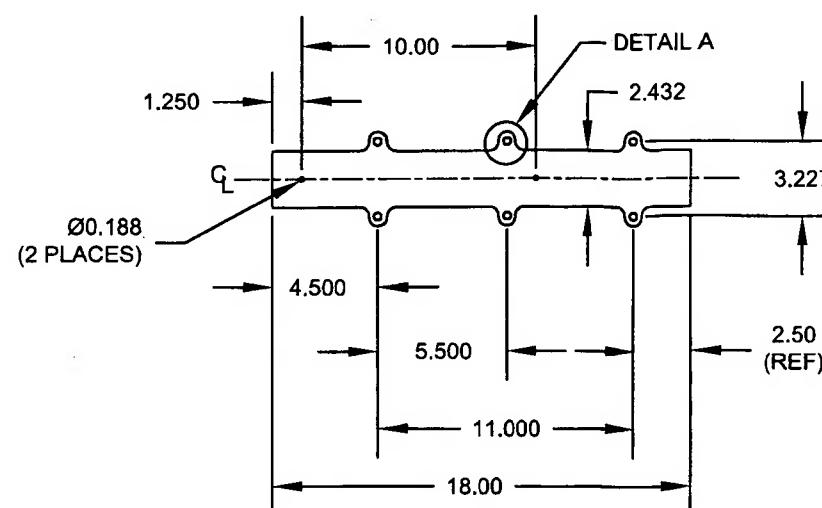
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DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>SI</i>	D3564	SHEET 2 OF 3
APPROVED	<i>HO</i>	TITLE	SCALE
DE APPR.	<i>SH</i>	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

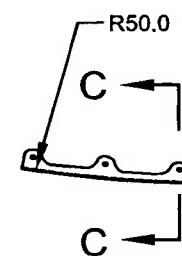
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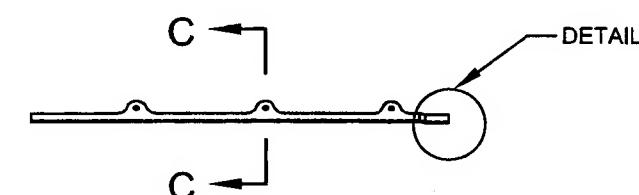
D3564-13F FLAT PATTERN



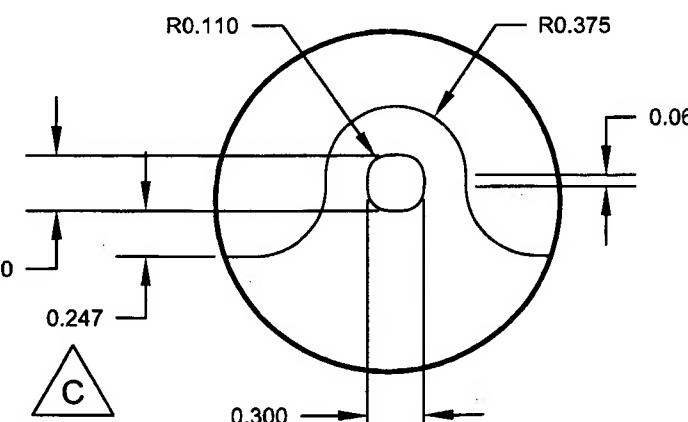
D3564-15F FLAT PATTERN



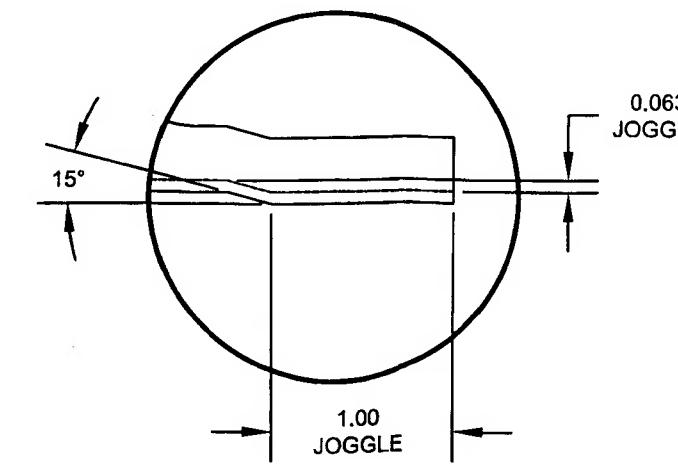
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL A
SCALE 1:1

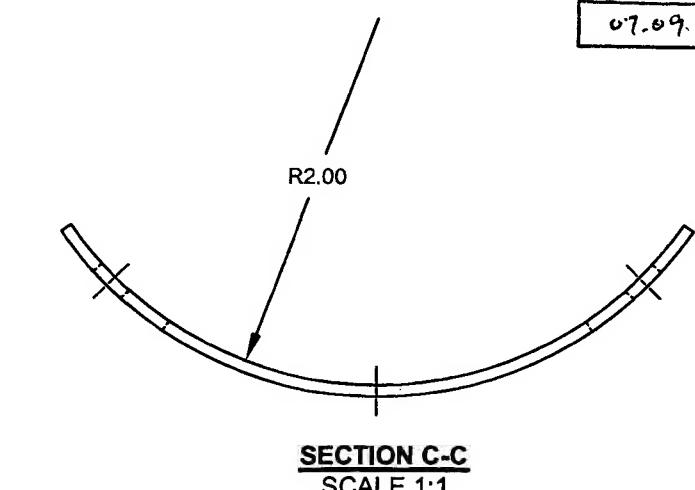


DETAIL B
SCALE 1:1

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



DETAIL D
(D3564-1/3-9/11 WELDING DETAIL)



SECTION C-C
SCALE 1:1

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WORK ORDER
NO. 38792

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKSLEY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 3 OF 3
APPROVED	AD	TITLE	SCALE
DE APPR.	SI	WEARSHOE	1:8
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